

Message Text

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ORIGIN COME-00

INFO OCT-01 CIAE-00 DODE-00 EB-11 NSAE-00 RSC-01 TRSE-00

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DRAFTED BY: MKRAVETZ/EPWALINSKY, DIR. PPD/OEA/BEWT

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R 232332Z MAY 74

FM SECSTATE WASHDC

TO USMISSION OECD PARIS

INFO AMEMBASSY MOSCOW

C O N F I D E N T I A L STATE 112735

EXCON

E.O. 11652: XGDS-1

TAGS: ESTC COCOM UR

SUBJ: EXPORT OF A MACHINING CENTER TO THE USSR - IL 1091

REF: BEWT CASE NOS. A. 109263; OC DOC. NO. 4818, SUPL. 1

B. 109264

THE UNITED STATES DELEGATION IS REQUESTED TO SUBMIT THE FOLLOWING
URGENCY EXCEPTION CASE PURSUANT TO COCOM DOC. REG.(73)3, PARA-
GRAPH 4(B):

1. THE UNITED STATES AUTHORITIES HAVE BEEN ASKED TO APPROVE THE
EXPORT TO THE USSR OF THE FOLLOWING EQUIPMENT WITH A TOTAL VALUE OF
\$281,976 AND COVERED BY IL 1091(A):

A. 1TYPE OM-1 MACHINING CENTER HAVING 3-AXIS PLUS INDEXING TABLE,

1 SET SPARE PARTS KIT

1SET TOOLHOLDERS AND CUTTING TOOLS

B. 1TYPE 28A OPTICAL TOOL SETTING GAGE

2. THIS EQUIPMENT IS CONSIDGNE TO IVANOVO MACHINE TOOL BUILDING
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PLANT, ULITSA STANKOSTROITELEY NO. 1, IVANOVO WHERE IT WILL BE

USED IN MANUFACTURING PARTS FOR MACHINE TOOLS.

3. A. THE OM-1 FEATURES FULL THREE AXIS COORDINATED AND SIMULTANEOUS CONTOURING CAPABILITY. THE PROGRAMMABLE INDEXING TABLE FEATURE ADDS AN ADDITIONAL DIMENSION TO THE FLEXIBILITY AND RAPID POSITIONING OF WOR ON THE MACHINE. IT HAS A FEED RATE OF 400 INCHES/MINUTE. BECAUSE OF THE FAST FEED RATES THE OM-1 IS PARTICULARLY SUITED FOR THE MACHINING OF LEAD ALLOYS, AND TITANIUM, AND THE HORSEPOWER MAKES IT SUITED FOR STAINLESS STEELS AND OTHER HARD TO MACHINE CURVALINEAR SURFACES. THE MACHINE IS EQUIPPED WITH G.E. 7533 CONTROLLER. THE OM-1 MEETS THE IL 1091 CRITERION AS IT EXCEEDS THE 100 INCHES/MINUTE CUTOFF, AND THE GE CONTROLLER HAS A RESOLUTION CAPABILITY OF .001 MM. THE G.E. 7533 CONTROLLER WAS DESIGNED SPECIFICALLY FOR USE ON DRILLING MACHINES AND MACHINING CENTERS. IT IS A HARD WIRED 3-AXIS CONTROLLER IN ITS STANDARD FORM WITH AN OPTION TO ADD A 2-AXIS CONTOURING CAPABILITY IN THE X & Y PLANE. SPECIFICATIONS OF THE OM-1 COMPARED WITH THE IL 1091 PARAMETERS ARE AS FOLLOWS:

MACHINE TOOL	IL-1091 AE	SUNDSTRAND OM-1
CHARACTERISTICS	NOTE	LIMITS
TABLE	72 INCHES	24 INCHES
POSITION ACCURACY	.001"/48"	.0005"/24"
SPINDLES	1	1
FEED RATE	100"/MIN.	400"/MIN.
HORSEPOWER	25	10
AXIS CONTROL	3	3 CONTINUOUS

CONTROL UNIT

CHARACTERISTICS	IL-1091 AE	NOTE	LIMITS	GE-7533
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TYPE	HARDWIRED	HARDWIRED
AXES	3-AXES SIMULTANEOUSLY	2 S/C
	COORDINATED	
RESOLUTION	.0001"/.002 MM	.0001"/.001 MM
COMPUTER INTERFACE	NONE	NONE

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B. THE OPTICAL TOOL SETTING GAGE HAS A READOUT CAPABILITY OF .0001 INCH AND SCALE ACCURACY OF .0002 INCH; THE TOOL SIZE CAPACITY-LENGTH: 8" MIN. TO 30" MAX. AND DIAMETER: ZERO TO 12" MAX. THIS UNIT IS USED FOR PRESETTING CUTTING TOOLS INTO TOOLHOLDERS EMPLOYED WITH AUTOMATIC TOOL CHANGERS. BROCHURES DESCRIBING THIS EQUIPMENT HAVE BEEN DEPOSITED WITH THE SECRETARIAT.

4. THE UNITED STATES AUTHORITIES CONSIDER THIS EXPORT REASONABLE
AND APPROPRIATE FOR THE STATED END USE, AND WOULD APPRECIATE THE
VIEWS OF MEMBER GOVERNMENTS. URGENCY PROCEDURE IS INVOKED IN ORDER
TO EXPEDITE DECISION WHETHER RETURN SHIPMENT FROM MOSCOW TO THE
UNITED STATES AT GOVERNMENT EXPENSE WILL BE NECESSARY.
FYI - BROCHURES HAVE BEEN AIRMAILED FROM COMMERCE ON 5/28/74. END
FYI. BROWN

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